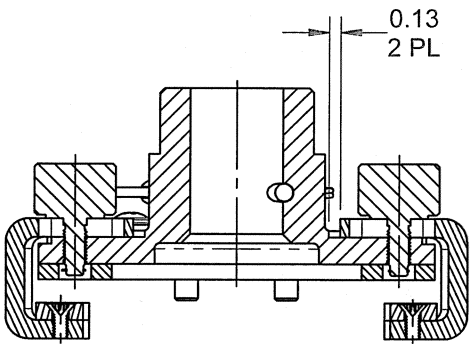
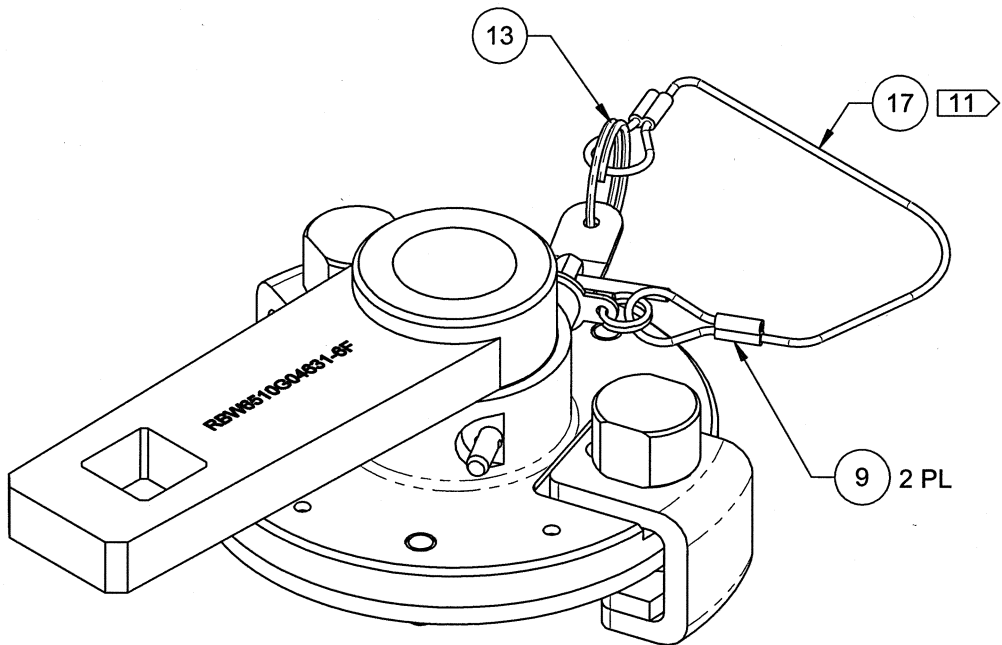


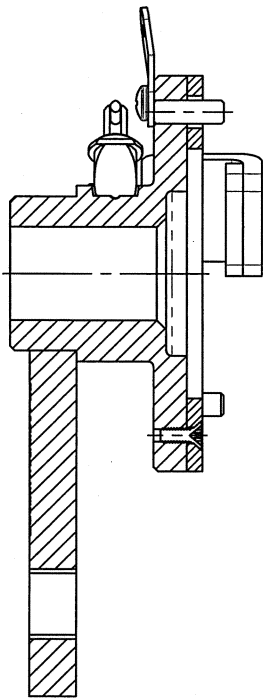
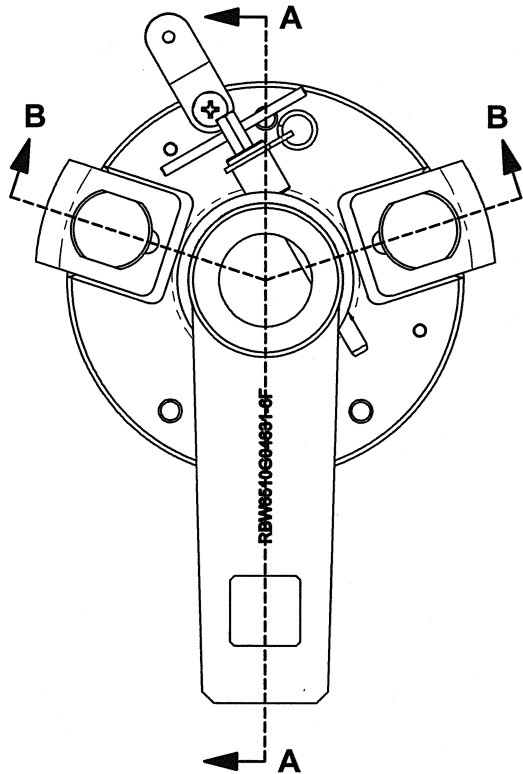
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6510G04631-6F-1	REACTION WELDMENT ASSEMBLY
-5	1	RBW6510G04631-6F-5	SPACER
-6	2	RBW6510G04631-6F-6	BRACKET
-7	2	RBW6510G04631-6F-7	BRACKET PROTECTOR
-8	2	RBW6510G04631-6F-8	BRACKET PIN
9	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
10	1	McMaster#90272A423 OR EQUIV.	ZINC PLATED STEEL PAN HEAD PHILLIPS SCREW #10-32 X 3/16" LG.
11	2	McMaster#90273A192 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 3/8" LG. X 82° CSK.
12	3	McMaster#90273A193 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #8-32 X 7/16" LG. X 82° CSK.
13	1	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
14	1	McMaster#94505A115 OR EQUIV.	17-4 PH SS T-HANDLE QUICK RELEASE PIN 3/16" DIA. X 1-1/2" USABLE LG.
15	1	McMaster#97840A460 OR EQUIV.	18-8 SS TAB FOR WIRE ROPE LANYARD 1.40" LG. X 1/2" WIDTH. X 1/16" THK.
16	2	McMaster#98410A110 OR EQUIV.	BERYLLIUM COPPER RETAINING RING FOR 3/16" OD. X 0.168" ID. X 0.015" THK.
17	1	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.



SECTION B-B
(ROTATED 18° CW)



RBW6510G04631-6F REACTION ASSEMBLY

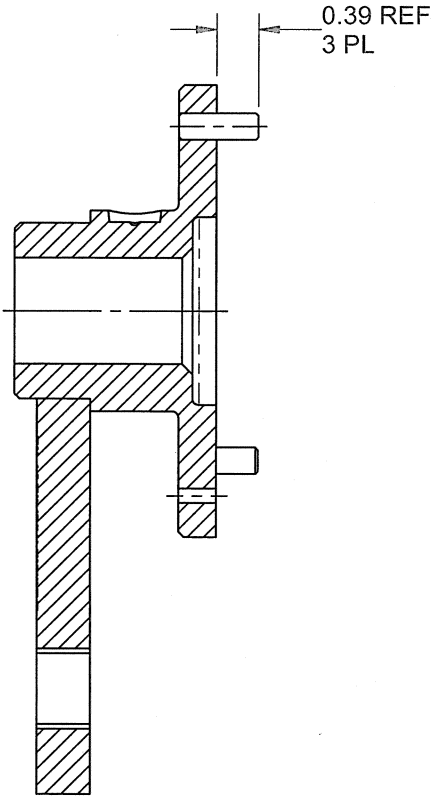
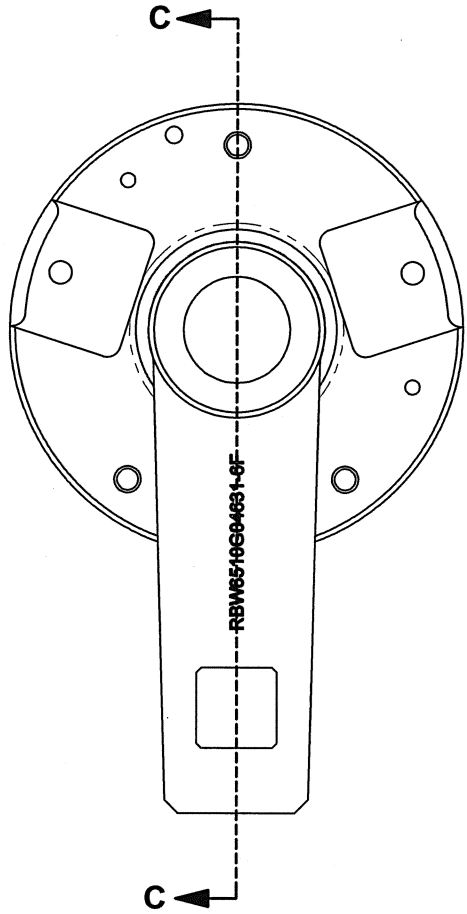
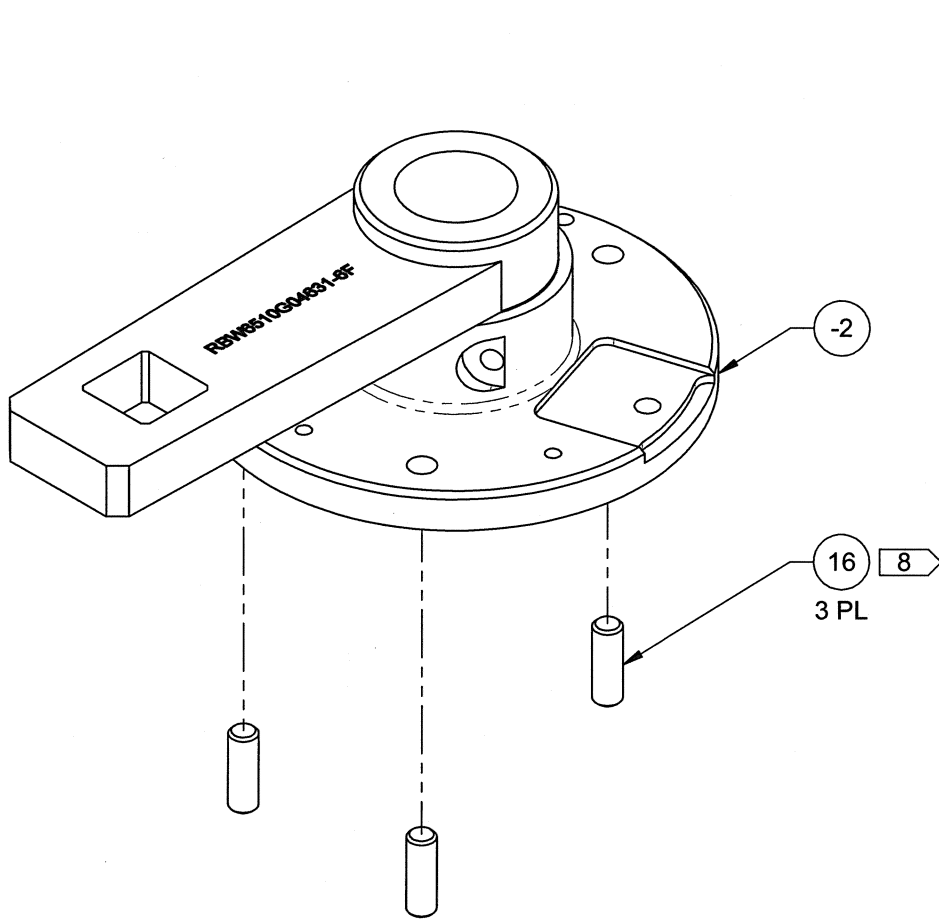


SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 10 AND 12 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 11 THEN ASSEMBLE WITH ITEM -6, AND REMOVE EXCESS
 - 10) INSTALL ITEMS 10, 11, AND 12 HAND TIGHT
 - 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 14
 - 12) ITEM -6 MUST SLIDE FREELY WHEN ITEM -8 IS LOOSENED
 - 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-807	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 1 OF 10
APPROVED	WJ	TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE	2019-07-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6510G04631-6F-2	REACTION WELDMENT
16	3	McMaster#98381A328 OR EQUIV.	BLACK OXIDE STEEL DOWEL PIN 1/4" DIA. X 3/4" LG.



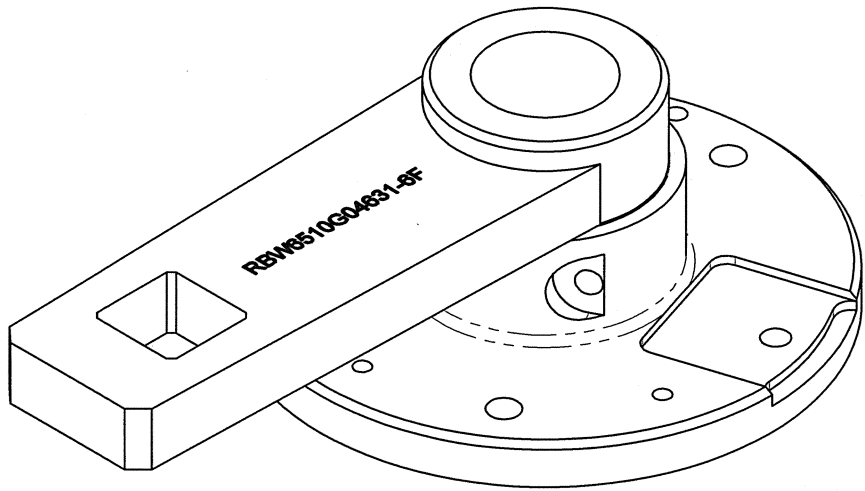
SECTION C-C

RBW6510G04631-6F-1 REACTION WELDMENT ASSEMBLY

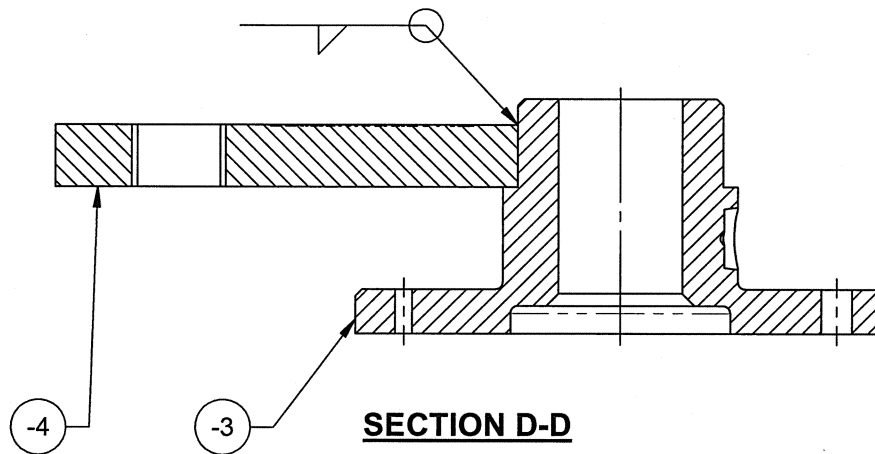
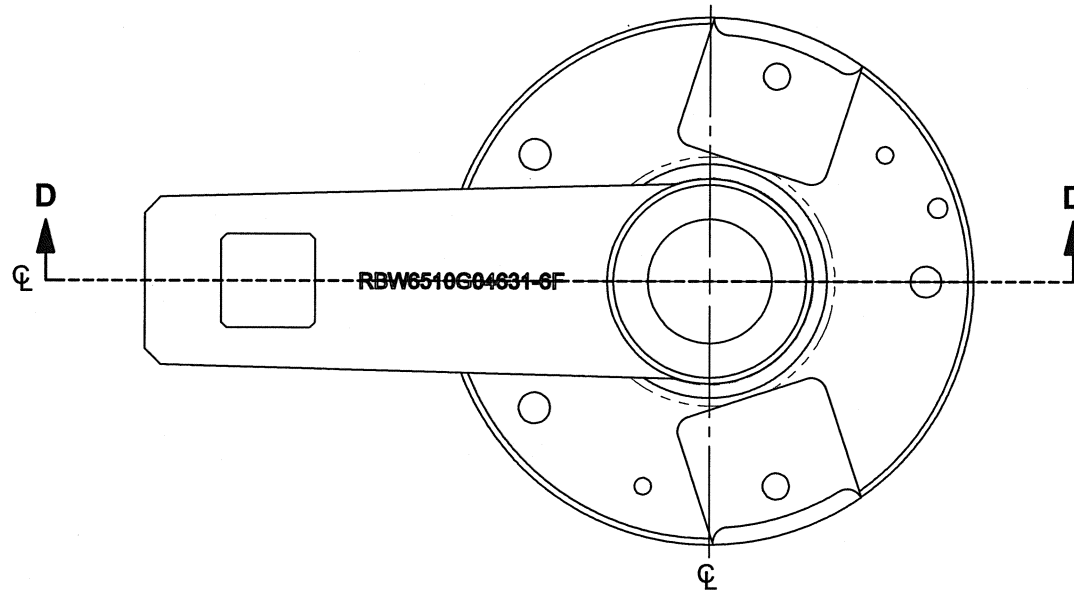
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 16 FLUSH WITH ITEM -2, AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 3 OF 10
APPROVED		TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE	2019-07-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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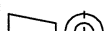
ITEM #	QTY	PART #	PART TITLE
-3	1	RBW6510G04631-6F-3	REACTION
-4	1	RBW6510G04631-6F-4	HANDLE



RBW6510G04631-6F-2 REACTION WELDMENT



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: 36-40 RC
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL WELD SPATTERS
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 4 OF 10
APPROVED		TITLE	SCALE
DATE 2019-07-09		REACTION ASSEMBLY	NTS 
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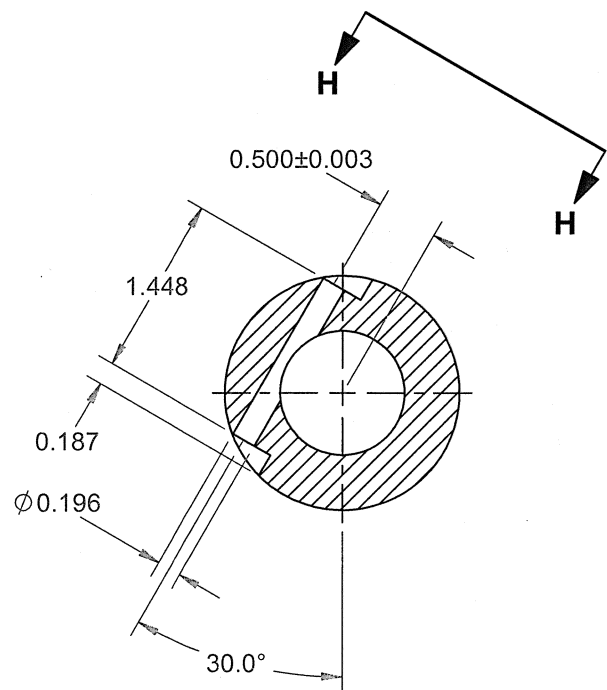
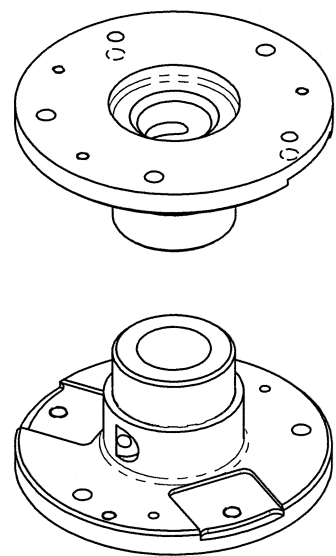
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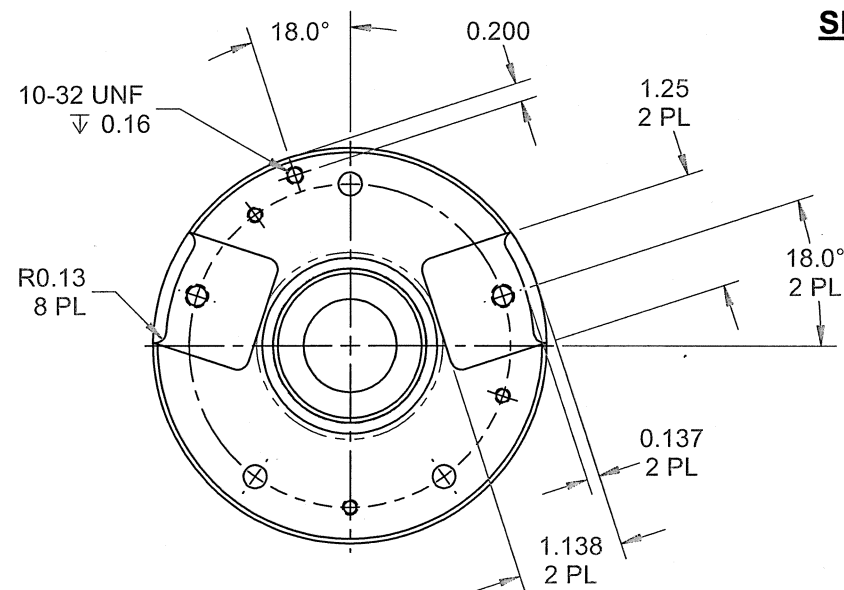
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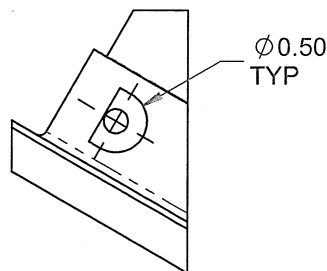
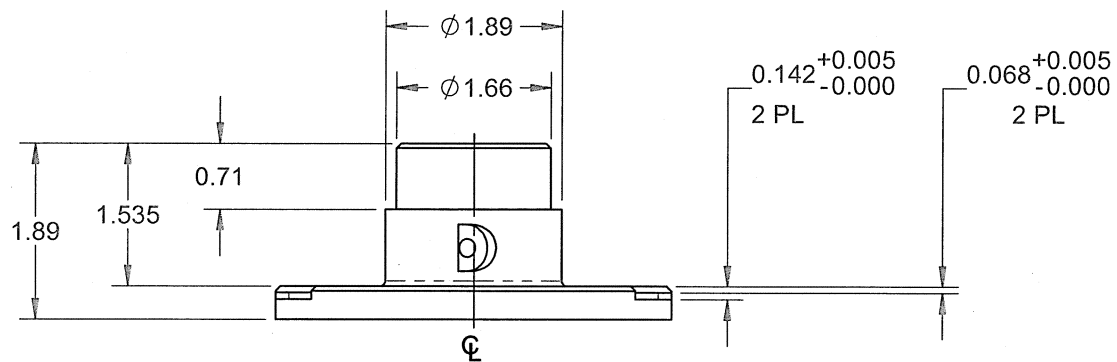
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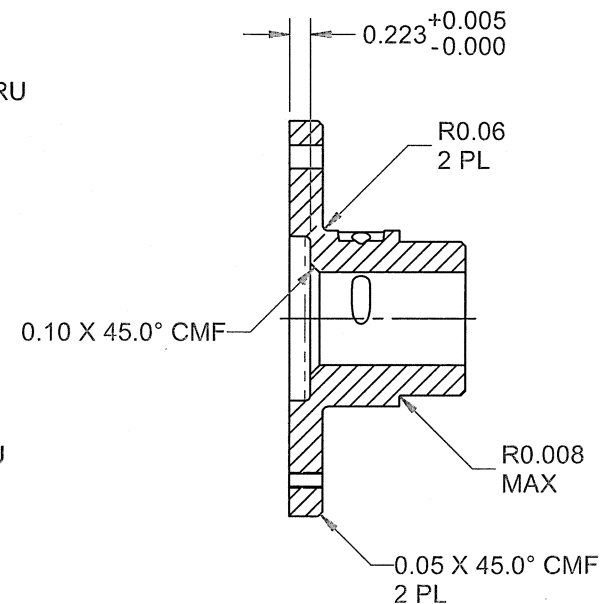
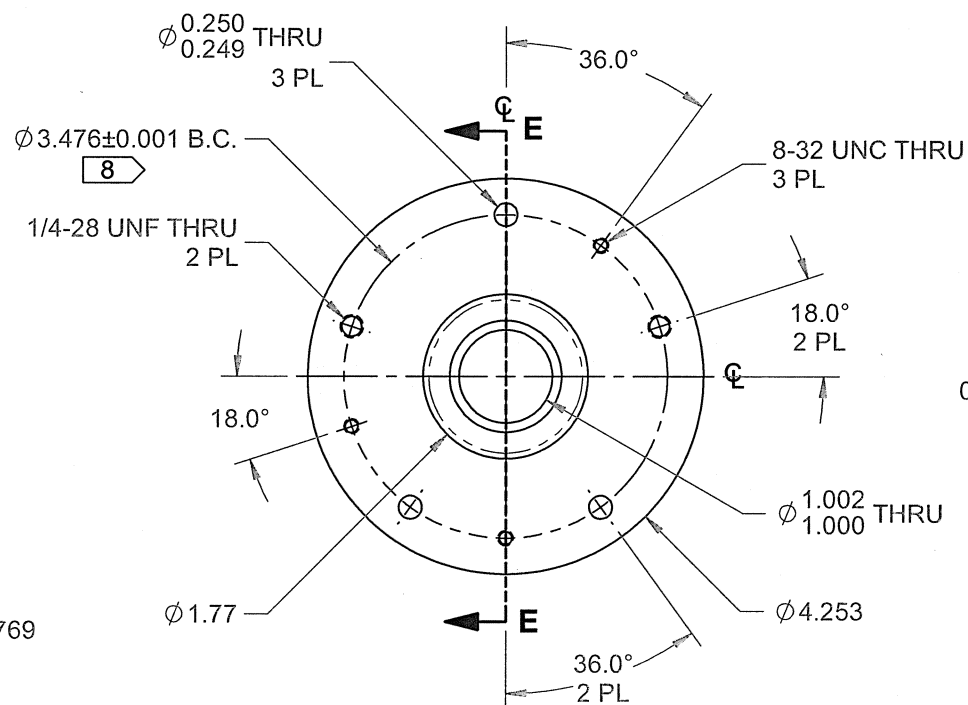
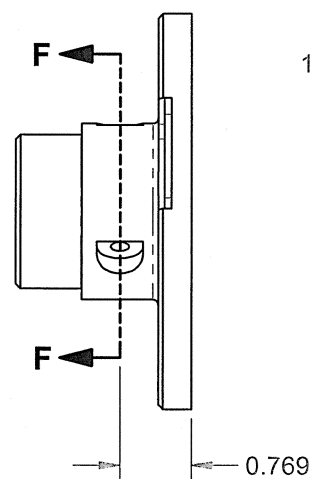
SECTION F-F



RBW6510G04631-6F-3 REACTION





VIEW H-H
2 PL



SECTION E-E

- NOTES:
- 1) MATERIAL: 4140
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) SYMMETRIC TOLERANCE OF ±0.001 ONLY APPLICABLE FOR DOWEL PIN HOLES OF Ø0.2500-0.2492

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DATE 2019-07-09		REACTION ASSEMBLY	NTS 
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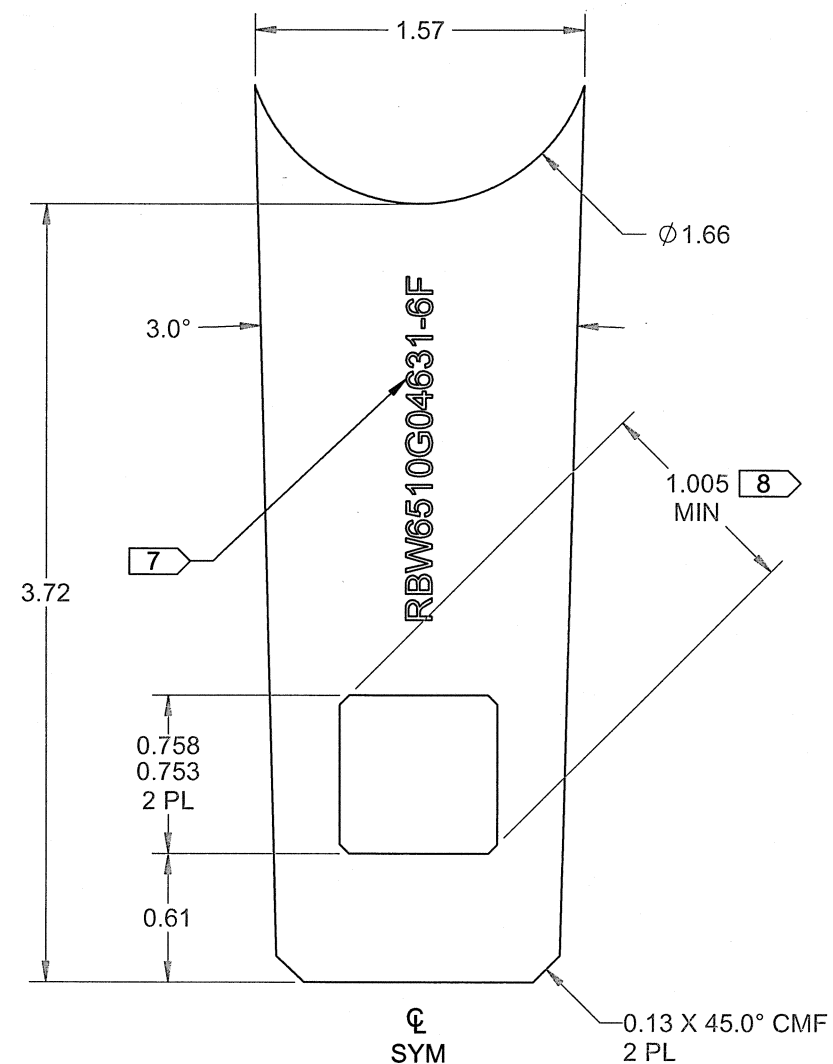
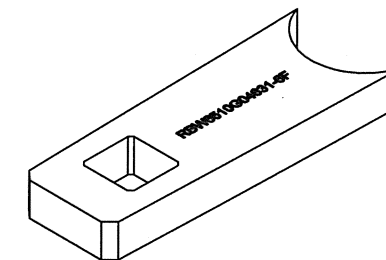
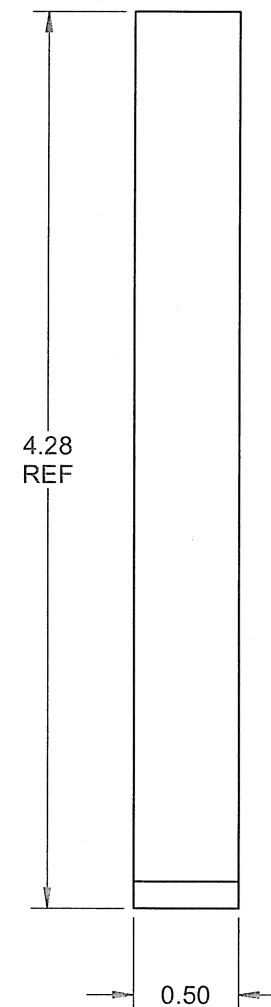
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**RBW6510G04631-6F-4 HANDLE**

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
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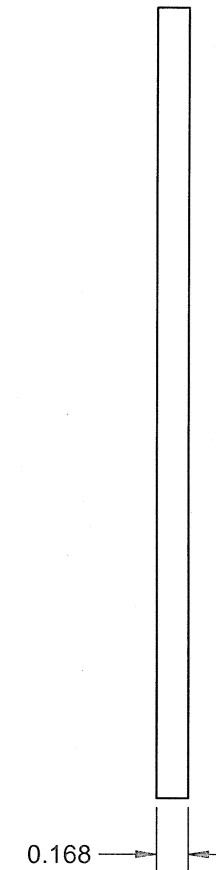
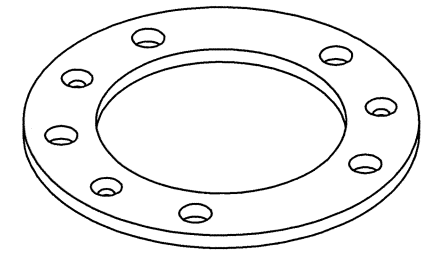
- 1) MATERIAL: 4140
2) HEAT TREAT: N/A
3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"



- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6510G04631-6F", AS SHOWN
8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 6 OF 10
APPROVED		TITLE	SCALE
		REACTION ASSEMBLY	NTS 
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NOTES:

- 1) MATERIAL: NYLON 6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 7 OF 10
APPROVED		TITLE	SCALE NTS 
DATE	2019-07-09	REACTION ASSEMBLY	
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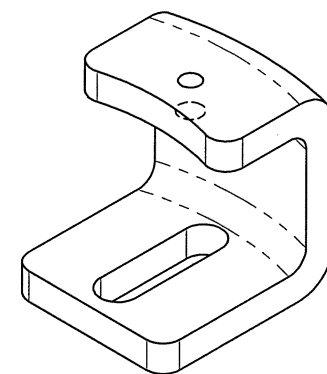
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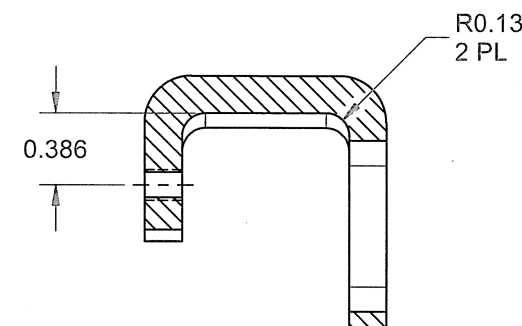
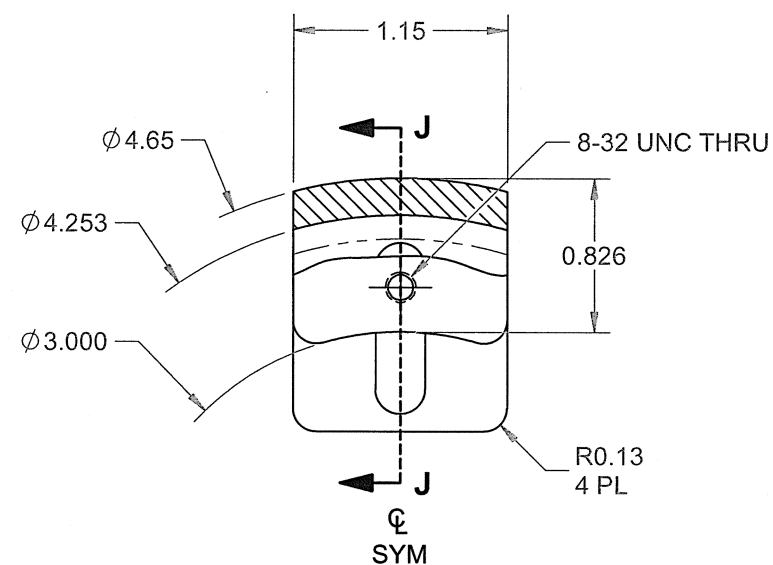
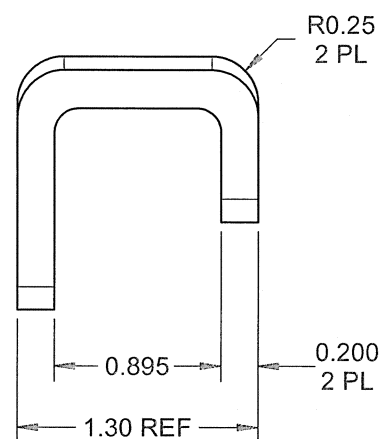
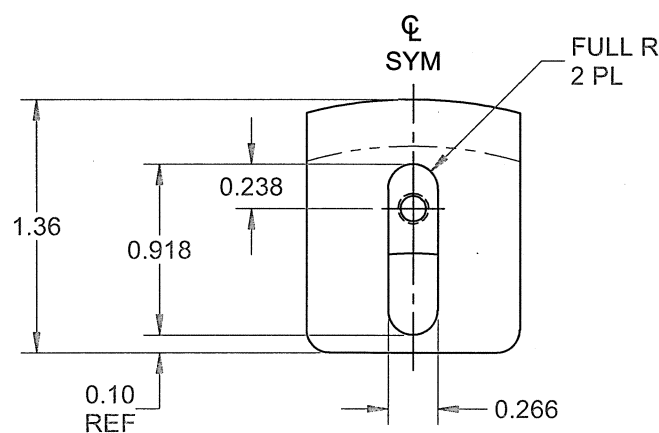


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**SECTION J-J****RBW6510G04631-6F-6 BRACKET****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 8 OF 10
APPROVED		TITLE	SCALE
		REACTION ASSEMBLY	NTS 
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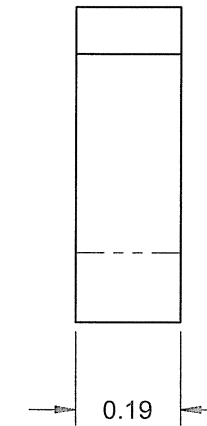
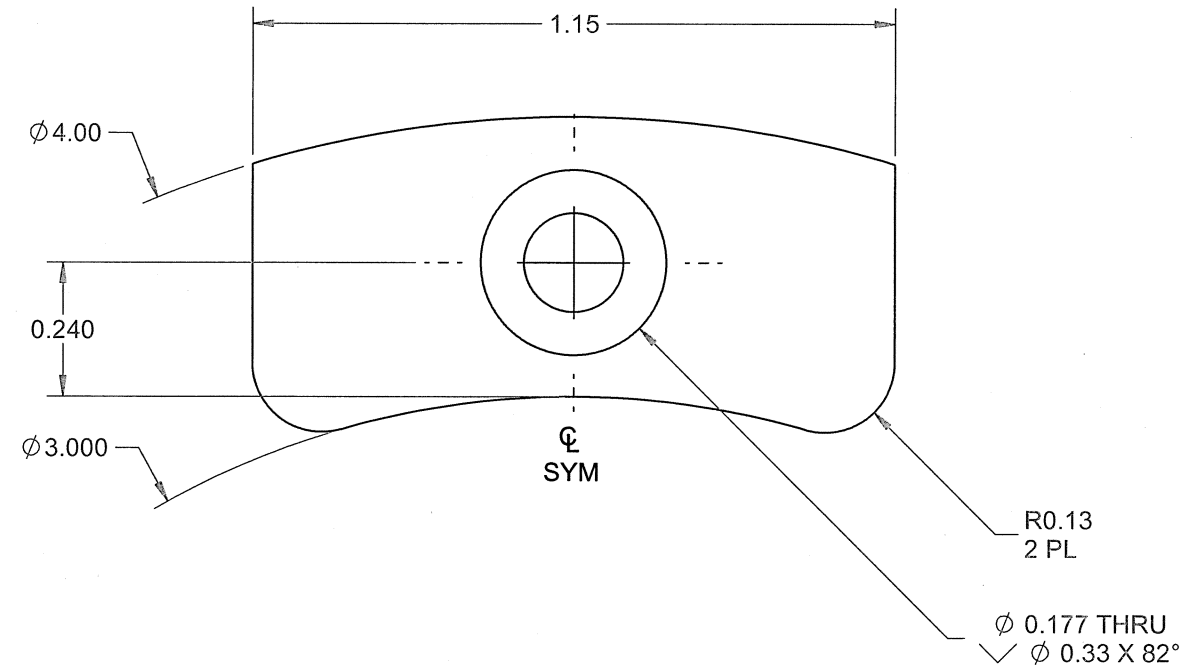
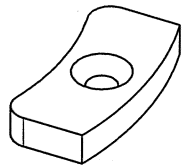
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RBW6510G04631-6F-7 BRACKET PROTECTOR

NOTES:

- 1) MATERIAL: NYLON 6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 9 OF 10
APPROVED		TITLE	SCALE
		REACTION ASSEMBLY	NTS
DATE	2019-07-09	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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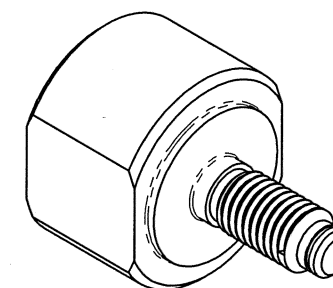
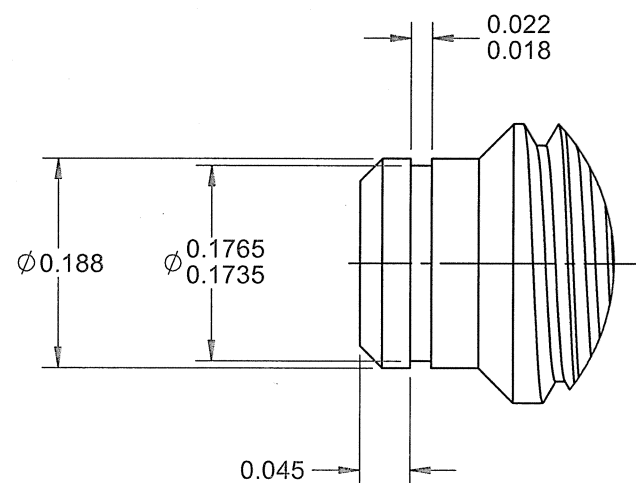
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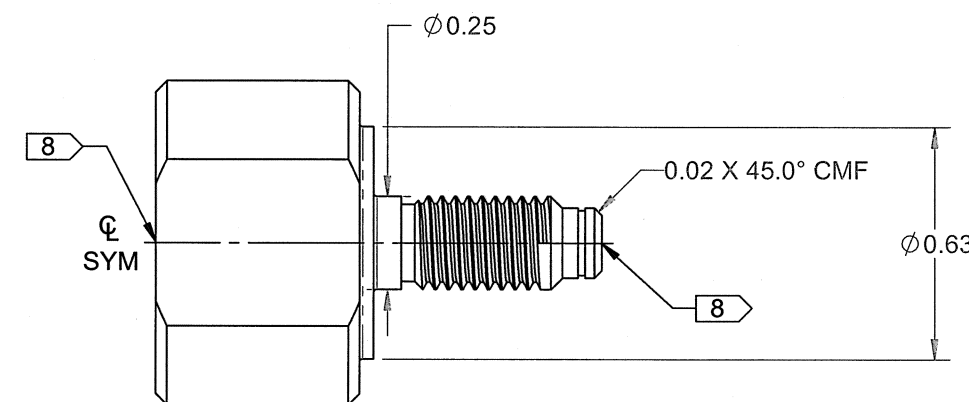
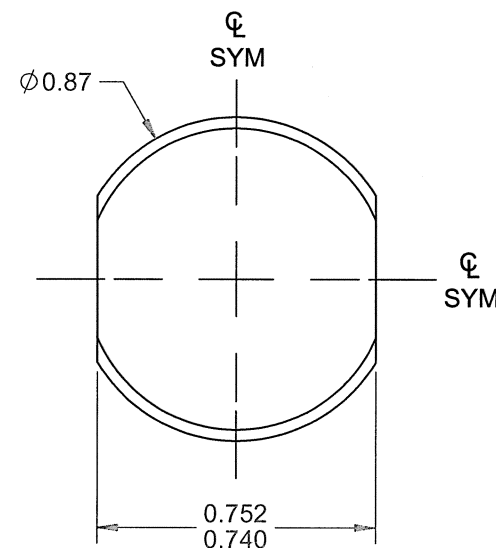
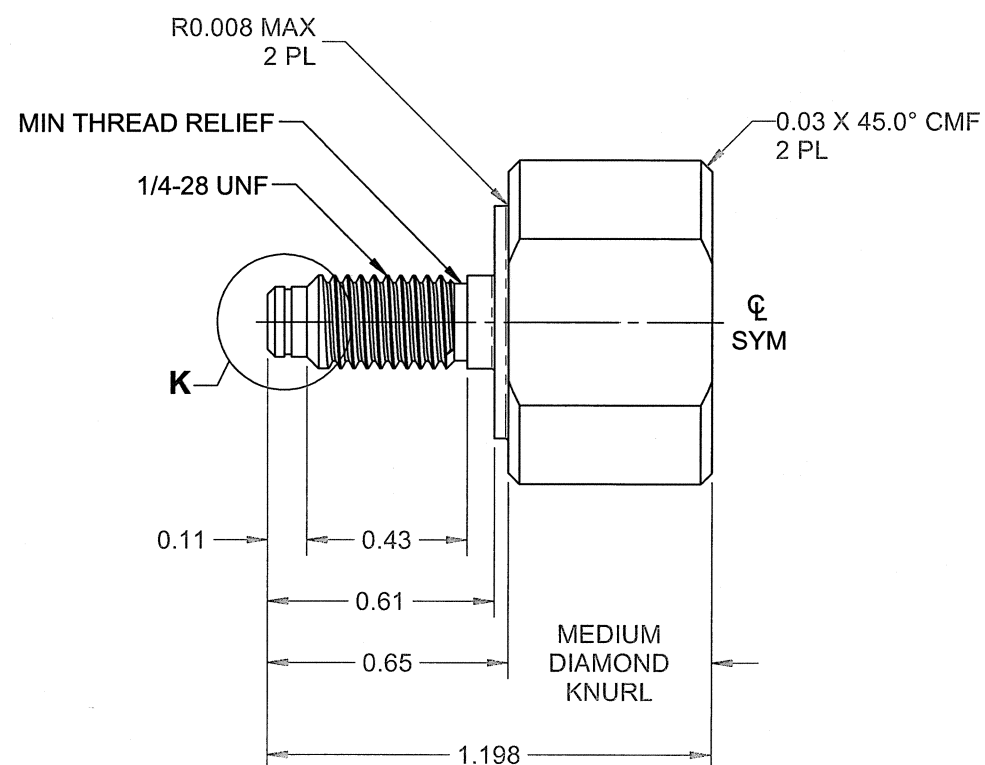
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DETAIL K

B



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RBW6510G04631-6F-8 BRACKET PIN**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

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DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6510G04631-6F	SHEET 10 OF 10
APPROVED		TITLE	SCALE
		REACTION ASSEMBLY	NTS 
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